

Date: Monday, 08/06/2009 1:12:32 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR SUPPORT KIT
Job Number : 48421	
Estimate Number : 12112	
P.O. Number :	Part Number : D412698015
This Issue : 08/06/2009 S.O. No. :	Drawing Number : IIN D412-698 REVD
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 46899	Material :
Written By :	Due Date : 15/06/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 09.06.08</u>	
Comment : Est Rev:C Removed Manufacturing 06-01-25 JLM Est Rev:D change to rev D ECN 1104 08-01-28 DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-015 CHG001

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D32001	Door Post Block
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3200-1 Door Post Block

B46519

4.0	D32003	Door Wedge
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3200-3 Door Wedge

B46520 x 7 B46905 x 5

5.0	D32011	Doubler
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

B46966

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 1:12:32 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SUPPORT KIT

Job Number: 48421

Part Number: D412698015

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D3201-1 Doubler

6.0

D32013

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3201-3 Angle

B36756x2

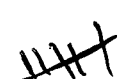
46967x4

SS 09/09/10 (x6)

7.0

D32014

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3201-4 Angle

B46012x1

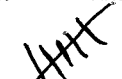
B46968x5

SS 09/09/10 (x6)

8.0

AN960JD10L

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD10L Washer

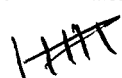
M109632

SS 09/09/10 (x6)

9.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L3 Nut (or -3)

M110844x49

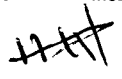
M111274x23

SS 09/09/10 (x6)

10.0

MS24693S277

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS24693-S277 Screw

M112082x9

M111425x63

SS 09/09/10 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5/08/06/18 (X6)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-015

Location: _____

PPP Rev: _____

Rev A

8/09/06/18 (X6)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/18 (X6)

Job Completion



C207/06/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 48421